Work Orde Tuesday, Octobe				*125	5260*							Page 1
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube Ass	·		Accept	*N900	040	100)*	Setup	Start Stop		S1*
	9/25/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					"IN	S2*
Approvals:	~ ~	nn: MLゴ	Date: <u>14-10-</u>	•		ate:		I	Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3391	I											
100 Skidtubes Skidtubes		2-Drill pilot saddle hole of saddle hole, using transfer of saddle on s	on one side only as per elles and GHW holes to 130" from Fwd indexin eldexing ridge on Fwd & 13391-021 in D3391-02 drill one fwd saddle holes using beng t-pins and clicos to d pilot holes in D3391 SIDE ONLY drill out 2	Do not drill "B" holes) and d Dwg D3391 Ø0.4375" exept for fwd sadd g Ridge as per Dwg D3391 & Aft end of skidtube as per 23 at 9.00" (see view z-z) Dle only to .188" dia, transfer DT 8149 locating from previ ensure perfect allingment, of 1023/1021 using drill press. 23 and forth saddle hole to 0.	Dwg D#391 drill all usly drill .188" pen up previusly les to 0.500" as) [-9	

Work Order: Part No. Part No. NCR No. DISPOSITION Rework Scrap Use-as-is Suspected Unapproved Cause Date Date Description of work order update Cause Doc/Data Equip/Tooling Handling/Pre Material DISPOSITION AGAINST DEPARTMENT/PROCESS Water Jet Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Finishing Composite Composite Supplier Engineering Machining Small Fab Composite Supplier Other Supplier Chief Eng Description Description Description Description Date Verification QC Inspecto	ルル
Work Order: Part No. Part No. NCR No. DISPOSITION Rework Scrap Use-as-is Suspected Unapproved Cause Date Date Description of work order update Cause Doc/Data Equip/Tooling Handling/Pre Material DISPOSITION AGAINST DEPARTMENT/PROCESS Water Jet Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Finishing Composite Composite Supplier Engineering Machining Small Fab Composite Supplier Other Supplier Chief Eng Description Description Description Description Date Verification QC Inspecto	ACE
Part No. Part No. Skid-tube Crosstube Prod. Eng. Coor. Quality	
Part No. Part No. Scrap Use-as-is Suspected Unapproved Use-as-is Large Fab Composite Sign & Verification QC Inspector	
NCR No. Suspected Unapproved Thermoforming Finishing Rec/Store/Packaging Other	
Root Cause Date Step Qty Or non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Handling/Pre Material	
Root Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Handling/Pre Material	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Handling/Pre Material	
Design Doc/Data Equip/Tooling Handling/Pre Material	
Doc/Data Equip/Tooling Handling/Pre Material	or
Equip/Tooling Handling/Pre Material	
Handling/Pre Material Control of the	
Material	
Operator	
Offset/Setup	
Process	
Supplier	
Training	
Transport	
Unapproved	
FAULT CATEGORY	
Landing Gear General Bending Bend Bend Folio/Program Outside Dimensions Pressure/Forced	4
Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	٦.
Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cu	uro
Cracks Blockerty Dathage / Detect Fract incorrect Fract in	uie
Cuffs Contamination Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pul	ılled
Crushing Countersink Misaligned/off center Positioned Wrong	iicu
Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other	
Inspection Strip in Tube Drawing Misread	
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

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Work Orde Tuesday, Octobe				*12	5260*						Page 2
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube As	combly		Accept	*N90	0040	100)*	Setup	Start Stop	*NS1*
	9/25/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	•	Cust Iten Custome					-	*NS2*
Approvals:	Process Pla	an:	Date:			Date:			Run	Start Stop	*NR1* *NR2*
Work Center II		paint marker ***DO NOT Open wearpl (10 holes) as Open wearpl (20 holes) as ***DO NOT Deburr and I aft end. 10- Locating wearplte hole	pilot holes using wearpla ; DRILL HOLES #3-19-2 ate holes of D3391-023 a per Dwg D3391 ate-holes of D3391-023 a per Dwg D3391 OPEN 2 MOST FWD W plow out all chips from in a from two fwd wearplate es in D3391-021 using D wearplate holes in D339	0 FROM FWD END (ssembly detail section ssembly detail section /EARPLATE HOLES side tube, scribe batch holes in D3391-023 di T8937	Ø0.250" holes with OF JIG G-G to Ø0.250" H-H to Ø0.297" ** # in D3391-023 at		Code	Oty	Qt.	y 1	Number Stamp
110 X1 1 \(\text{ \text{*1 1 \chi \text{*}}}\) QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00					<u></u>		DAS 38 9-89

DQA:	9	w	Date:	14/1	2/11		-	ANE OF		DD 4.T.E			DART
QA Closed:,	$\langle \rangle$	Da	Date:	14/1	2/1	WORK ORDER NON	-00	JNFOI	RIVIANCE / UI		ork Order up	date only	AEROSPACE
Work Orde	er:	1250	2600	1		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	No.	D3	391-	0Z]	3	Rework Scrap Use-as-is Suspected Unapproved)	ı	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			C.		Desci	ription of work order update	1	nitial	Act		Sign &		0.01
Cause Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	N	Date 14-11-13	Step	Qty	ŕ	or non-conformance orplate hales of tion 6-6 apond) to 0.297		DAS 12 9-89	Descr A ccepted 1 (learand only, N	iption la . Le hale a stress-	Date 048 12 989 14/11/14	Verification	QC Inspector DAS 38 9-89
							FAI	ULT CA1	rEGORY				
Landi	Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Ur ions Incomplete/U ned/off center sled	· -	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Twi		e		Finish Fit/Function		4	Calibration Sequence				

Work Ord Tuesday, Octobe				*125	5260*						Page 3
Item ID: Revision ID:	D3391-023			Accept	*N900	040	100)* :	Setup Stai	171	S1*
Item Name:	Mid Tube As	ssembly							Sto	*N	S2*
Start Date:	9/25/14	Start Qty: 1.00	*1*		Cust Item 1	ID:					
Required Date:	10/06/14	Req'd Qty: 1.00	*1*		Customer:						
Reference:			•								
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:	_	F	Run Star	^1 <i>\</i> J	R1*
	QC:		Date:	SPC (Y/N):	D	ate:	···		Stop	, *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		Chemical Conversion Co	oat per QSI005 4.1	0.00				•			
120 HandFinish		Memo		0.00					4	14-11	17 De
Hand Finishing	-										

130

QC7-Inspect Chemical Conversion Coat

0.00

1.30

Memo

0.00

Quality Control

DQA:			Date:	e: WORK ORDER NON-CONFORMANCE / UPDATE									**	DART	
QA Closed:			Date:			WORK ORDER NON	-C(JNFOI	RIMANCE / U		Work	Order up	odate only	\neg	AEROSPACE
	-					DISPOSITION				AGAINST (<u> </u>		
Work Orde	er: _						_			AGAINST		it i i vi Ci v i j	, i NOCESS		
						Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	۷o.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Thermoforming Finishing Rec/Store/Packaging							Other
NCR I	۷o. <u>-</u>				!	Suspected Unapproved]	Large Fab Composite				Supplier			
Root					Desci	ription of work order update	1	nitial	A	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	n	QC Inspector
Design .		•													
Doc/Data															
Equip/Tooling															
Handling/Pre	Ш														
Material	$H \mid \cdot \mid \cdot \mid$										ĺ			ŀ	
Operator	Ш														
Offset/Setup	Ш														
Process			İ	į											
Supplier											Ì				
Training												_		1	
Transport]							≽∀					
Unapproved]				<u> </u>								
							FA	ULT CAT	regory						
Landi	<u> </u>	,			_	General	_	1		_	_		-	,	
	Щ	Bending			_	Bend		1	rogram	Ļ		utside Dim	<u> </u>		Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route	\vdash	Grain					tolerance	┙	Set-up
	Ш	Cracks				Broken/Damage/Defect		Hardwa		1		irt Incorre	}	_	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs	<u></u>	Inspecti	ion Incomplete/l	Jnqualified		rt Lost/Mi	- +	$\overline{}$	Weld
	Cuffs				Contamination		-	ions l'ncomplete	⊢	 -	rt Moved			Wrong Stock Pulled	
	Crushing				<u> </u>	Countersink		- 1	ned/off center	· [_	sitioned V			
	Heat Treat					Cut Too Short		Mislabe		L	Po	wer Loss/	Surge		Other
	Inspection Strip in Tube					Drawing		Misread			_				
		Marks/Ch				Drill Holes		Off-set			_				
	-	Turning S	-			Finish		Out of 0	Calibration		_				
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence						

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Work Ord Tuesday, Octob				*12!	5260*		·					Page	: 4
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube As	ssembly		Accept	*N900	040	100)*	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date Reference:	9/25/14 e: 10/06/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:							
Approvals:		an:		Tooling: SPC (Y/N):		te: te:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center I 140 *1 10* Skidtubes Skidtubes	ID	2-C'sink flo	it bag holes as per dwg at bag holes as per dwg ube for welding	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty — —		Reject Number	Insp. Stamp	_
		4-Bond wet Adhere for A/R Sikafle batch#:	o in place as per Dwg D339 12 hours) ex exp: <u>/5-8-15</u>	-		Wd_		/4-11	-18				DA

150

QC5- Inspect part completeness to step on W/O

0.00

150

0.00

Memo

DQA:		Date):	WORK ORDER NON-CONFORMANCE / UPDATE									DART
QA Closed:		Date	::		WORK ORDER NON		JNFOR	TIVIANCE / C		W	ork Order up	odate only	AEROSPACE
Work Orde	r:			·	DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
Part N NCR N	0	geranderen bes			Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		l	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desc	ription of work order update		Initial	Ad	ction		Sign &		
Cause	Da	te Step	Qty		or non-conformance		nief Eng	1	cription		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	3												
						FAI	ULT CAT	rEGORY					
Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instructi Misalig Mislabe Misread Off-set	on Incomplete/L ions Incomplete, ned/off center led	/Unclear		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
. -	Turning Sequence Wave/Twist in Tube				Finish Fit/Function	-	4	Calibration Sequence					

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Work Orde				*125	5260*			, -			Page 5
Item ID: Revision ID:	D3391-023			Accept	*N900	040	100)* s	Setup Sta	171	S1*
Item Name: Start Date: Required Date: Reference:	Mid Tube As 9/25/14 10/06/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item :	ID:			3.0	* *N	S2*
Approvals:		an:		Tooling: SPC (Y/N):		ate:		R	Run Sta Sto	^ \ \	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Skidtubes		Skidtubes Memo 1-Weld cross 2-grind weld	sbolt spacer as per dwg D3	0.00	M129285	- -			Ø	14-1	119
¹⁷⁰ *17∩*		QC10- Inspect visual per	QSI004- ground welds	0.00				1			D,D⊁ 3,36 9 .9-6 9
QC Quality Control		Memo		0.00	-						14-11-20
¹⁸⁰ *18∩*		QC5- Inspect part compl	eteness to step on W/O	0.00							یم 38
QC		Memo		0.00				1			9-89

Memo

DQA:			. Date:		·	WORK ORDER NON-CONFORMANCE / UPDATE								RT
QA Closed:			Date:								ork Order up	date only	AERO	JSPACE
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N NCR N	•					Rework Scrap Use-as-is Suspected Unapproved		ŧ .	Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineeri Qual Oth	lity
Root					Desc	ription of work order update		Initial	Action	1	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ct	nief Eng	Descripti	ion	Date	Verification	QC Insp	ector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		Succession of the complete of												
							FA	ULT CA	TEGORY			,		
Landir	ng C	iear				General								
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube					Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misreaa Off-set Out of	ion Incomplete/Unqua tions Incomplete/Uncl gned/off center eled d	lear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Fo Set-up Temperatur Weld Wrong Stock	e/Cure	
	\dashv	_	•			Fit/Function		┥	Sequence					

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Tuesday, October	07, 2014 10:39:25	AM		"125	1/11/11						1 age 0	
Revision ID:	03391-023 Aid Tube Assembly			Accept	*N900	0040	100)* s	etup Star Stop		S1* S2*	
Start Date: 9 Required Date: 1 Reference:		Qty: 1.00 Qty: 1.00	*1* *1*		Cust Item 1 Customer:							
	Process Plan:		Date:	Tooling: SPC (Y/N): .		ate:		R	un Star Stop	^IVI	R1* R2*	
Sequence ID/ Work Center ID 185 *185 HandFinish Hand Finishing	Operat Descrip Pressure	otion Wash per QSI005 4	I.3 SINE AS PER PAR09-04	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	7
100 Powdercoat Powder Coating	White Gl	oss(Ref:4.3.5.1) pe Memo START TIME: OVEN TEMPE FINISH TIME:	3:05.	0.00				14	8 14-	12-1		
* ? OO* QC Quality Control	QC3- Ins	pect Part Finish Memo		0.00				1 × 4		_\(\(\(2	DA 18	S

Pro

DQA:	\mathcal{A}	$\frac{WY}{2}$	Date:	14/12	2/13			٠						[™] AART
QA Closed	\mathcal{A}	/DS)	Date:	14/	1121	WORK ORDER NON $\mathcal{U}(\mathcal{O})$	1-C(ONFO	RMANCE / I		Wo	rk Order up	odate only	A E R O S P A C.E
Work Or	der:	ĺΖ	520			DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS	
Part	No.	D3=			3	Rework Scrap Use-as-is Suspected Unapproved		1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		/	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Desci	ription of work order update or non-conformance		Initial nief Eng		action scription		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Toolin Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved				 	ot iv iubo	erfoction was four	4	DAS 12 9-89	shrip. Les as a consiste primer !	Sected and Jouch mer /paint	υp ·	and Adaptive Marketine	DAS 15 9-89	DAS 9 9-89
						· ·	FA	ULT CA	TEGORY					
Land	Landing Gear Bending Centre Not Concentric Cracks Broken/Damage/Defect Burrs Cuffs Countersink Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Géneral Bend BoM/Route Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish					Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/ tions Incomplete gned/off center eled d	e/Unclear		Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	\vdash	Wave/Tw				Fit/Function	\vdash	┥	Sequence Sequence		-			

Work Ord Tuesday, Octobe				*125			•		Page 7			
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube Asso	embly		Accept	*N900	040	100)*	-	Start Stop		S1* S2*
	9/25/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:				''IV	. 7/"		
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	D:				Start Stop		R1* R2*	
Sequence ID/ Work Center, II 230)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
220 HandFinish Hand-Finishing -		HandFinishing Memo 1-Install Ins	erts as per Dwg	0.00	·			14				11/08
240		QC5- Inspect part compl	eleness to sten on W/O	0.00				a)		-		DAS
240 QC Quality Control		Memo	10 sep 02 1170	0.00	•							38 9-89 14-12-0

250

250 Packaging

Packaging

Identify as per dwg & Stock Location:

0.00 D412.742-043 / B126411

Memo

0.00

DQA:			. Date:		·	WORK ORDER NON	DART						
QA Closed:			Date:			WORK ORDER NON	AEROSPACE						
Work Ord	er.					DISPOSITION							
						Rework			Skid-tube Crosstube			Water Jet	Engineering
Parti	Part No.					Scrap Use-as-is		i	Machining	Small Fab Finishing		od. Eng. Coor. ore/Packaging	Quality Other
NCR I	NCR No.					Suspected Unapproved		Thermoforming Finishing Large Fab Composite				Supplier	
Root					Desci	ription of work order update	1	Initial	А	ction	Sign &		
Cause	_	Date Step Qty				or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector
Design	Ш												
Doc/Data													
Equip/Tooling	Н		}										
Handling/Pre	H												
Material	Н												
Operator	Н												
Offset/Setup	\vdash												
Process	\vdash												
Supplier Training	\vdash												
Transport	Н												
Unapproved	Н		ļ										
опарріочен			L	i			FΔI	ULT CAT	L TEGORY		1.		
Landi	ne G	iear				General	• • • • • • • • • • • • • • • • • • • •	021 0,11					
		Bending				Bend] Folio/P	rogram	Г	Outside Di	mensions [Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route		Grain	J	-	-	er tolerance	Set-up
	П	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorr)	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/l	Unqualified	Part Lost/I	Missing	Weld
·		Cuffs				Contamination		Instruct	ions Incomplete	/Unclear	Part Move	_	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	, [Positioned		
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Los	s/Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	4	_		_	
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of 0	Calibration				
	Wave/Twist in Tube					Fit/Function	—						

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Work Ord Tuesday, Octob				*125260*								Page 8	
Item ID: Revision ID: Item Name:	D3391-023			Accept	*N90004010			↑* Setup		Start Stop		S1* S2*	-
Start Date: Required Date Reference:	9/25/14: 10/06/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:	Process P QC:	lan:	Date:		Date:				Run	Start Stop	*N	R1* R2*	
Sequence ID/ Work Center I 260 *260*	D	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	_
QC Quality Control		Memo — —	<u>-</u>	0.00	··· _		(A	R	-\2-	10		

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			Work Order update only									
Work Order:						DISPOSITION		1							
Part No						Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				-	Desci	ription of work order update		nitial	Act	tion	Sign &				
Cause	ļ	Date	Step	Qty		or non-conformance	i i	ief Eng		ription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
							FAI	JLT CAT	EGORY						
Landi 	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave					General Bend BOM/Route Broken/Damage/Defect Burrs		Folio/Program Grain Hardware Inspection Incomplete/Unqualified			Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing		Pressure/Forced Set-up Temperature/Cure Weld		
	Cuffs Crushing Heat Treat					Contamination Countersink Cut Too Short		Instructions Incomplete/Unclear Misaligned/off center Mislabeled			Part Moved Positioned V Power Loss/	Vrong	Wrong Stock Pulled Other		
	Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube					Drawing Drill Holes Finish		l	Calibration						
	\	vave/ i wi	stin lub	е		Fit/Function		Out of S	equence						

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Picklist Print

Tuesday, October 07, 2014 10:39:25 AM

Work Order ID: 125260

125260

Parent Item:

D3391-023

D3391-023

Parent Item Name:

Mid Tube Assembly

Start Date: 9/25/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.10.20New Issue

KJ/EC IPP B06.02.10ECN773 dwg rev.D EC

IPP C 07.03.20 IPP D 07.03.28

rev F dwg

re-format

EC EC EC

IPP E 07.10.31 ecn 1053P

IPP Rev:F ECN 1056 07-11-13 DD

verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP

Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100		Manufactured	No			100	Each	57.0000	1	1	_		
D2500-1-	100			·				· —	**	R. F) 14	-10	-9
				Location		Loc (<u>Oty</u>	Loc Code			, ,		1
				HALL	82373 86065		57 8 49						
D3389-1		Manufactured	No			140	Each	6.0000	1	1			
D3389-1									**		_		
Web				Location		<u>Loc (</u>	<u>Oty</u>	Loc Code			DG	C	14-11-

Location Loc Qty Loc Code

DQA:			Date:			WORK ORDER MON	DAR'	DART						
QA Closed:			Date:			WORK ORDER NON-	AEROSPAC	: E						
Work Orde	ar.					DISPOSITION								
Part No						Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root	Des				Desci	ription of work order update		nitial	Act	ion	Sign &			
Cause	D	Date Step Qty				or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	İ
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FAL	ULT CAT	regory			•		
Landir	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Ui ions Incomplete/U ned/off center eled	· –	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Wrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
ŀ	_		st in Tub	e	-	Fit/Function		1	Sequence					

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114884 3 AELS4-1032-130 Purchased ALS4-1032-130 No 230 Each 3,693.000

LG

LG001

AI S4-1032-130

Rivnut

Loc Qty Loc Code ST267 3693 M126109 57 M128211 48 M128649 3588

80 40 40

20

**

20

V20

D3591-1/13115533 (11)

Page 2

DQA:			Date:										A DT
	•					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA	ATE			A E R O S P A C E
QA Closed:			Date:	,						Wo	ork Order up	date only	
Work Orde	sr.					DISPOSITION			A	PROCESS			
Work Orac		**.				Rework			Skid-tube Cr	rosstube]	Water Jet	Engineering
Part N	lo.					Scrap	 			mall Fab	Prod	d. Eng. Coor.	Quality
	-					Use-as-is			Ğ I—	Finishing		e/Packaging	Other
NCR N	10				_	Suspected Unapproved				mposite			
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date Step Qty				or non-conformance		ief Eng	Descriptio	on	Date	Verification	QC Inspector
Design													
Doc/Data				:									
Equip/Tooling			·										
Handling/Pre													
Material													
Operator	· ·	0											
Offset/Setup													
Process													
Supplier													
Training							ĺ						:
Transport	_								•				
Unapproved									ε				
							FΆι	ULT CAT	regory	···		·	
Landir					_	General		1 .			1		٦
	-	Bending				Bend		ŧ .	rogram		Outside Dim	<u> </u>	Pressure/Forced
		Centre No	t Concer	ntric	-	BOM/Route		Grain			Over/Under		Set-up
}	Cracks					Broken/Damage/Defect	_	Hardwa			Part Incorrec	<u> </u>	Temperature/Cure
	Crimp/Kink/Ripple/Wave				<u> </u>	Burrs		l '	ion Incomplete/Unqual	}	Part Lost/Mi	ssing	Weld
	Cuffs					Contamination	_	1	tions Incomplete/Uncle	ar	Part Moved	<u></u>	Wrong Stock Pulled
	Crushing					Countersink	<u> </u>	1 -	ned/off center	<u> </u>	Positioned W		1
	$\overline{}$	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabe			Power Loss/S	Surge	Other
	\dashv	Inspection	· .	Tube	-	Drawing	L	Misread					
		Marks/Ch			_	Drill Holes		Off-set					
	_	Turning Se			<u> </u>	Finish		1	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function	Function Out of Sequence						

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